

Date: Thursday, 11/29/2007 11:00:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSBOLT SPACER
Job Number : 36013	
Estimate Number : 11010	
P.O. Number :	Part Number : D2649
This Issue : 11/29/2007 S.O. No. :	Drawing Number : D2649 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 34612	Material :
Written By : <u>JA 07.11.29</u>	Due Date : 12/10/2007 Qty: <u>395</u> Um: Each
Checked & Approved By : <u>JA 07.11.29</u>	
Comment : Est F 02.03.26 Added turning on Cobra NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W
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Comment: Qty.: 0.2975 f(s)/Unit Total : 89.23951(s)
 6061-T6 Tube .375 x.058W 119.0000
 Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

M103841 M106469
 M105641 M104897
 Batch _____ 07/12/10

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Machine as per folio FA214 on cobra machine.

07/12/10 H.A./SC

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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07/12/10 H.A./SC

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/12/13

396

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: LG

07/12/18

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007/12/18

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

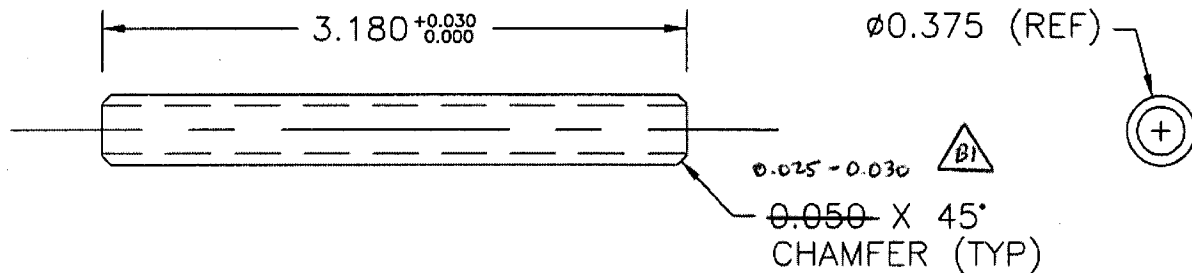
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DMJ</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMJ</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# (P) 02.06.13	REDUCE CHAMFER PER TSR 1246.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36013